

Date: Tuesday, 5/16/2006 10:41:13 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : LUG
 Job Number : 27152
 Estimate Number : 10337
 P.O. Number : N/A Part Number : D28073
 This Issue : 5/16/2006 S.O. No. : N/A Drawing Number : D2807.REV C
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : MACHINED PARTS Drawing Revision : C
 Previous Run : 26757 Material : N/A
 Written By : *See comment below* Due Date : 5/30/2006 Qty: 50 Um: Each
 Checked & Approved By : *06.05.16 w*
 Comment : Est A 05.06.02 New Issue KJ/JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M303R0750 303 Round Bar .75"



Comment: Qty.: 0.1094 f(s)/Unit Total : 5.4705 f(s)
 Material: 303 Round Bar Ø0.750"
 (M303R0.750)

Batch: M100806*MS 06/05/29*

2.0 HARDINGE HARDINGE CNC LATHE SMALL



Comment: HARDINGE
 Turn as per Folio FA529 and Dwg D2807 Dwg Rev: C

2-Deburr

*MS 06/05/29**50*

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*MS 06/05/29**50*

4.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: Haas #1
 Machine as per Folio FA528 and Dwg D2807 Dwg Rev: N/A
 Folio Rev: N/A

06.06.02 N/A Machined Manually

2-Deburr

*06/06/09**50*

5.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*06/06/09**50*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: 13 Date: 06/06/13

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Tuesday, 5/16/2006 10:41:13 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG

Job Number: 27152

Part Number: D28073

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SA 06.06.09

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

57387

06/12/06 (50)

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/06/03 (58)

Job Completion



u 06.06.13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

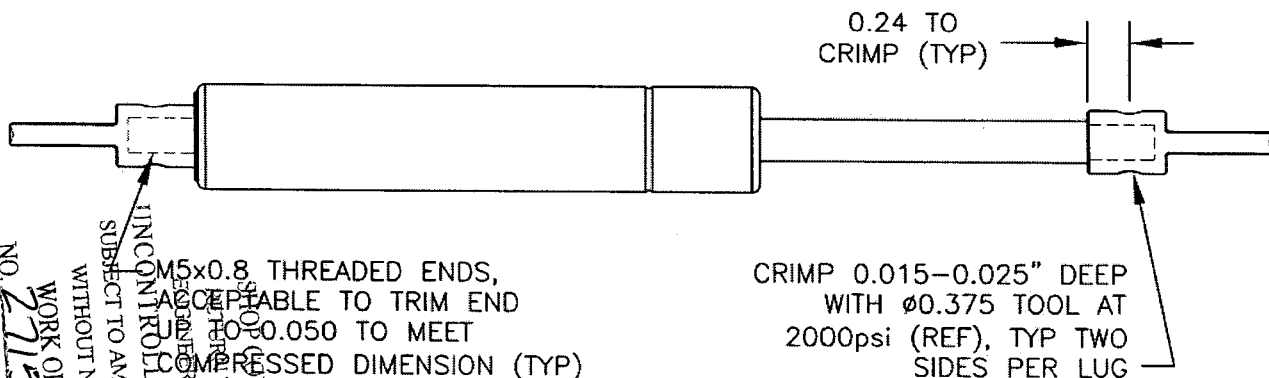
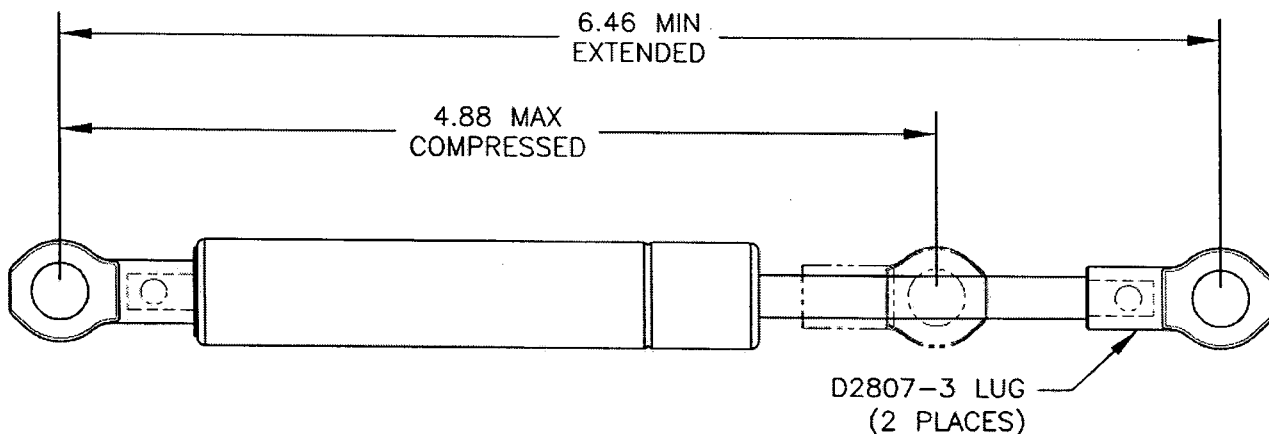
NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART

RELEASED
#5-06-16

DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD
CHECKED		APPROVED		HAWKESBURY, ONTARIO, CANADA
DATE	05.05.25	TITLE	D2807	REV. C
			GAS SPRING	SHEET 1 OF 2
A	00.11.03		NEW ISSUE	SCALE 1:1
B	05.03.16		ADD FINISH	
C	05.05.25		CHANGE SPRING TO SS, ADD -3 LUG	



M5x0.8 THREADED ENDS,
ACCEPTABLE TO TRIM END
TO 0.050 TO MEET
COMPRESSED DIMENSION (TYP)

NO. 27152
WORK ORDER
SUBJECT TO AMENDMENT
WITHOUT NOTICE

D2807 GAS SPRING

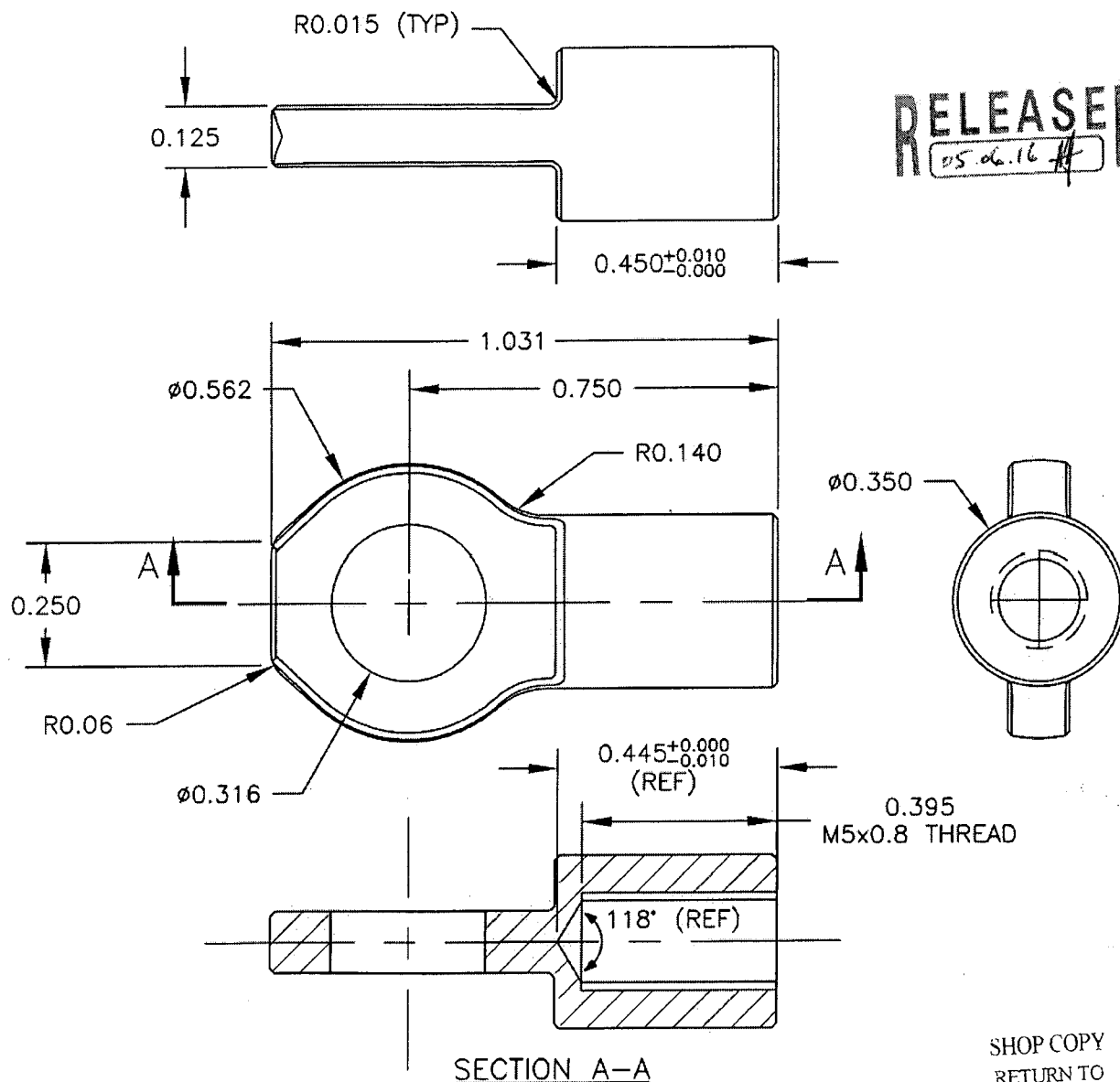
- SPECIFICATION: SS GAS SPRING
ACCEPTABLE LOAD RANGE IS 25 lb MIN TO 45 lb MAX
M5x0.8 THREADS

POSSIBLE SUPPLIER: ArvinMeritor Motion Control Systems, Leicester, UK
P/N: SXF6S6050080S6L-115N
(REF: 80mm LONG CYLINDER, 50mm STROKE, 115N LOAD)

- ALL DIMENSIONS ARE IN INCHES
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DART

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2807	REV. C SHEET 2 OF 2
DATE 05.05.25	TITLE GAS SPRING		SCALE 3:1

**D2807-3 LUG**

- 1) MATERIAL: AISI 303 ROUND BAR (REF DART SPEC. M303R)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.015
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

SHOP COPY
RETURN TO
ENGINEERING
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 27152

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